



# Work Order ID 77746

**\*77746\***

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Tuesday, December 20, 2011 4:14:12 PM

Item ID: D3196-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bar  
 Start Date: 12/20/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/26/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	B.A	11/12/23		4	0		
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140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	SW/AS	11-12-23		4	0		
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150 <b>*150*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 9:40 FINISH TIME: 10:10 3200F	0.00 0.00							4X0 m/l 11/12/23
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**Work Order ID 77746**

Tuesday, December 20, 2011 4:14:12 PM

**\*77746\***

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## Quality Control

OK 12/01/02

11-12-29  
(4)

# Picklist Print

Tuesday, December 20, 2011 4:14:11 PM

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Work Order ID: 77746

Parent Item: D3196-3

Parent Item Name: Bar

Start Date: 12/20/2011

Required Date: 12/26/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.500 6061-T6 Bar .750 X 1.50		Purchased	No			100	f	28.2860	2.89	12.168421		12/11-12-21	

Location

Loc Qty

Loc Code

MAT002

28.286

116604

1.5

118182

2

118844

0.786

119513

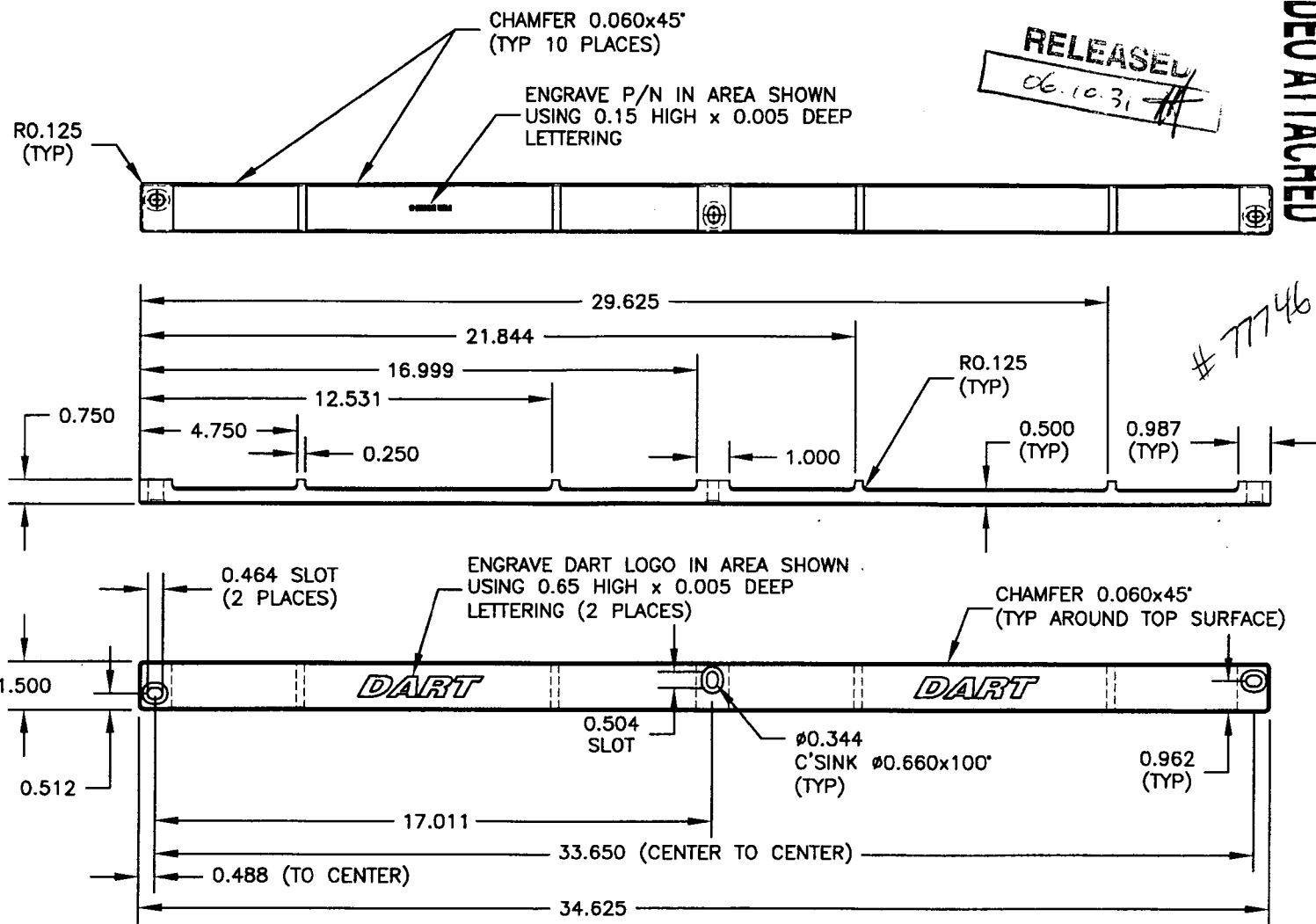
24

12.2

**DART**

**DETACHED**

RELEASED  
06.10.31



**D3196-3 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	APPROVED	DRAWING NO.	REV. C
CHECKED	APPROVED	D3196	SHEET 2 OF 3
DATE	TITLE	SCALE	
06.10.31	BAR	1:5	

**DART AEROSPACE LTD**  
HAMKESBURY, ONTARIO, CANADA

DRAWING NO. D3196	TITLE BAR	REV. C	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3196-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>ASS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.08.27	DATE 08.08.28	DATE 08.08.29	DATE 08.08.29	DATE 08.08.29	DATE 08.09.04	

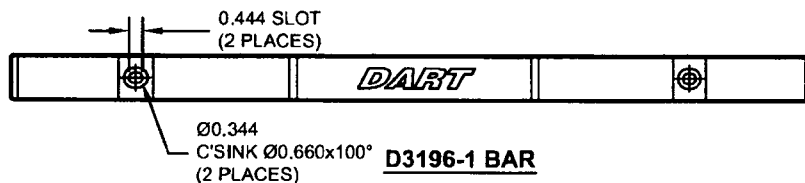
SHEET 1 MODIFY SLOT DIMENSIONING ON D3196-1 AS SHOWN:

IS:



D3196-1 BAR

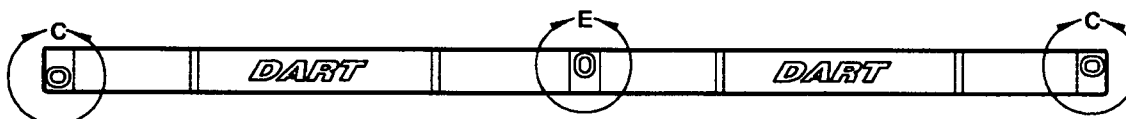
WAS:



D3196-1 BAR

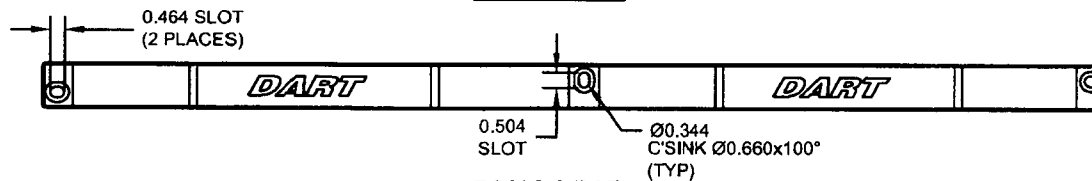
SHEET 2 MODIFY SLOT DIMENSIONING ON D3196-3 AS SHOWN:

IS:



D3196-3 BAR

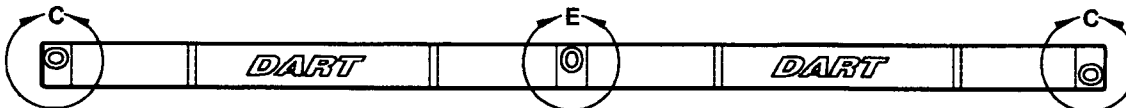
WAS:



D3196-3 BAR

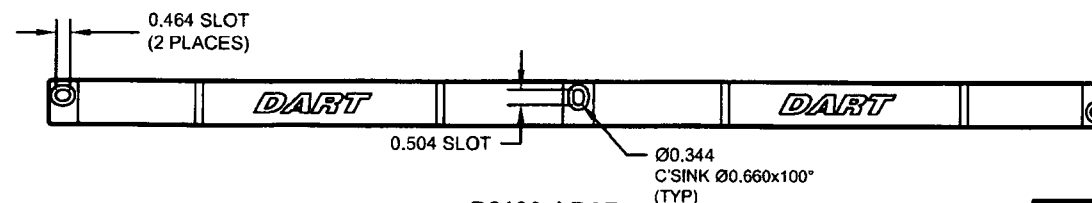
SHEET 3 MODIFY SLOT DIMENSIONING ON D3196-4 AS SHOWN:

IS:



D3196-4 BAR

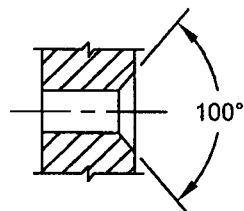
WAS:



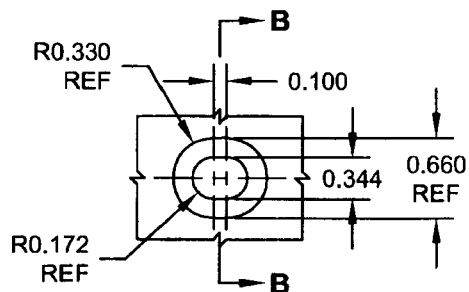
D3196-4 BAR

*# 77746*

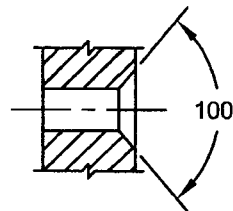
DRAWING NO. D3196	TITLE BAR	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3196-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>ASS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.08.27	DATE 08.08.28	DATE 08.08.29	DATE 08.08.29	DATE 08.08.29	DATE 08.09.04		



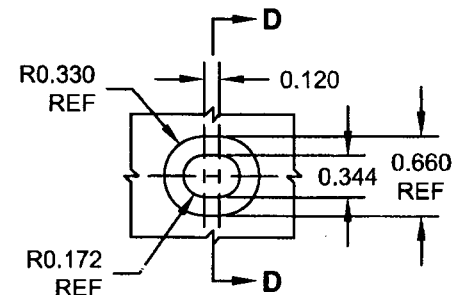
**SECTION B-B**



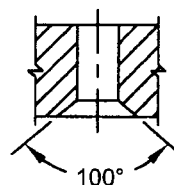
**DETAIL A**



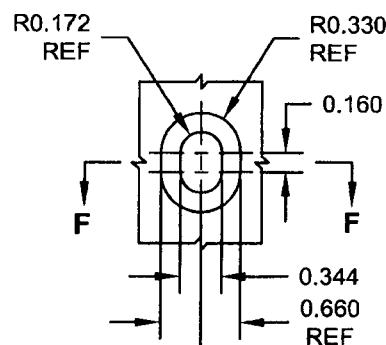
**SECTION D-D**



**DETAIL C**



**SECTION F-F**



**DETAIL E**

NOTE: THIS CHANGE HAS BEEN DONE TO CLARIFY SLOT DIMENSIONS ONLY. NO CHANGES HAVE BEEN MADE TO THE PARTS  
SEE NCR 08-051 FOR FURTHER INFORMATION  
ALL OTHER INFORMATION REMAINS UNCHANGED

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	77746
<b>Description:</b> Bar		<b>Part Number:</b>	D3196-3
<b>Inspection Dwg:</b> D3196 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	✓			
33.650	+/-0.005	33.650	✓			
0.488	+/-0.005	.488	✓			
17.011	+/-0.010	17.011	✓			
0.512	+/-0.005	.508	✓			
1.500	+/-0.010	1.500	✓			
0.464	+/-0.010	.462	✓			
0.504	+/-0.010	.501	✓			
Ø0.344	+0.006/-0.001	.342	✓			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	.660 x 100				
0.962	+/-0.005	.958	✓			
0.750	+/-0.010	.749	✓			
4.750	+/-0.010	4.750	✓			
12.531	+/-0.010	12.531	✓			
16.999	+/-0.010	16.999	✓			
21.844	+/-0.010	21.844	✓			
29.625	+/-0.010	29.625				
0.250	+/-0.010	.250				
1.000	+/-0.010	1.000				
R0.125	+/-0.010	.125				
0.987	+/-0.010	.990				
0.060 x 45°	+/-0.010 x 0.5°	.060 x 45°				

<b>Measured by:</b> K.F.	<b>Audited by:</b> B.A.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/12/22	<b>Date:</b> 11/12/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	